

Work Order ID 114715

April-25-14 2:52:16 PM

Page 1

Item ID: D4712-043

D 4 7 1 2 - 0 4 3

Accept

114715

Revision ID:

B 1 1 4 7 1 5

N9000040100

Setup Start

NS1

Item Name: Bracket Assembly

R E V - C

Stop

NS2

Start Date: 3/12/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/12/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4712	C								
100	Pick Kit	0.00							
1100	FLOW WATER JET								
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
10
9-89

DAS
27
9-89

14/4/30

23x

14/04/30

DAS
36
9-89

23

Work Order ID 114715

April-25-14 2:52:16 PM

114715

Page 2

Item ID: D4712-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 3/12/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 3/12/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>ST/B</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

23x 14-5-1

MLC 14-05-01

(N) 14-05-01

DAS
26
9-89

Picklist Print

April-25-14 2:52:15 PM

Page 1

Work Order ID: 114715

114715

Parent Item: D4712-043

D4712-043

Parent Item Name: Bracket Assembly

Start Date: 3/12/14

Required Date: 3/12/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4712-3		Manufactured	No			100	Each	3.0000	1	20			
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

D4712-3

Bracket

14/04/30

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

3

111164

3

DAS
36
9-89

Purchased

No

100

Each

18,153.00

4

80

14/04/30

DAS
36
9-89

MS20426AD3-2

Rivet

Location

Loc Qty

Loc Code

Mezz

18153

1173

8873

13276

9280

2350-18-C3Y

Purchased

No

100

Each

661.0000

2

40

14/04/30

DAS
36
9-89

2350-18-C3Y

Rigid Receptacle

Location

Loc Qty

Loc Code

ST395

661

M127987

6

M128047

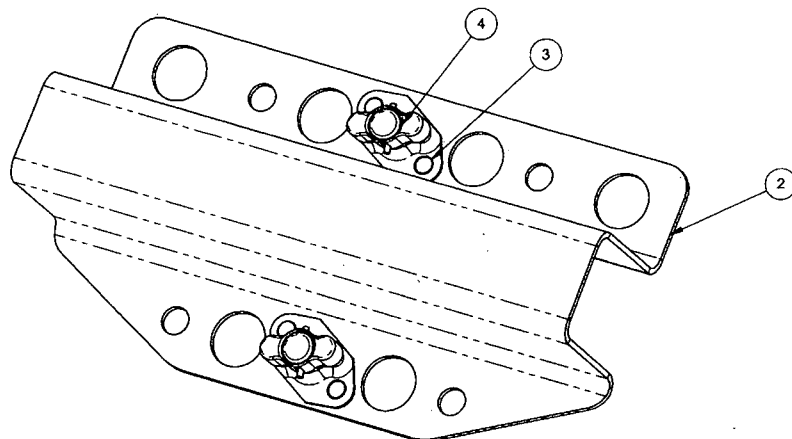
655

46

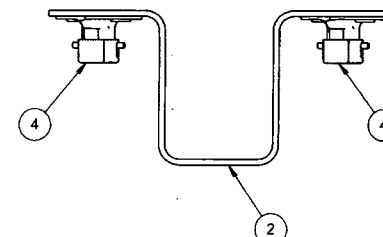
M128754 (92)

23a

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4712-043	BRACKET ASSEMBLY
2	1	D4712-3	BRACKET
3	4	MS20426AD3-2	RIVET
4	2	2350-18-C3Y	RIGID RECEPTACLE



D4712-043 BRACKET ASSEMBLY



RELEASED
2013-12-23

ASS ECN 13-705

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

C	Ø 0.129 WAS Ø 0.098 (ZN C4-3)	RF	13.09.11
B	REMOVED -041/-5; REMOVE CSK ON D4712-1F (ZN D4-3); Ø 0.221 WAS Ø 0.500 (ZN B4-3); REVISE D4712-3/-043 (ZN B4-4, B4-5)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO. D4712 REV. C SHEET 1 OF 5	
MFG. APPR.	NS		
APPROVED	CA	TITLE SUPPORT BRACKET ASSY SCALE NTS	
DE APPR.	CA		
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8 7 6 5 4 3 2 1

D

D

C

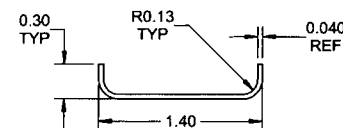
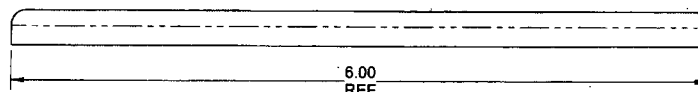
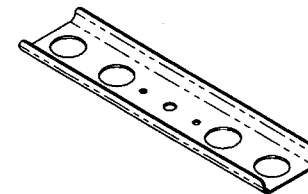
C

B

B

A

A



D4712-1 BRACKET

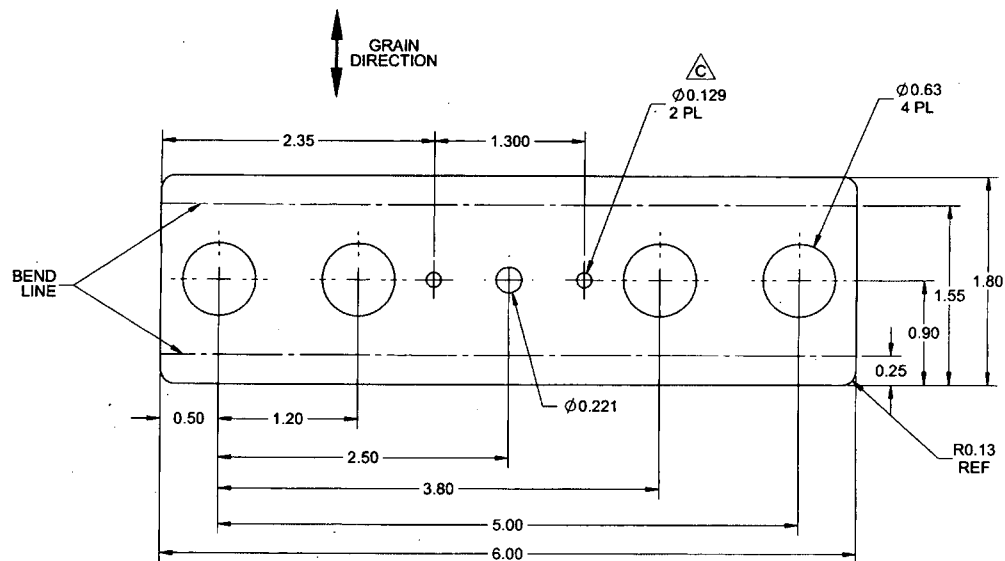
RELEASED
2013-12-23
AS

NOTES:

- 1) MATERIAL: MAKE FROM D4712-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	NS	D4712	SHEET 2 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SUPPORT BRACKET ASSY	NTS
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8 7 6 5 4 3 2 1



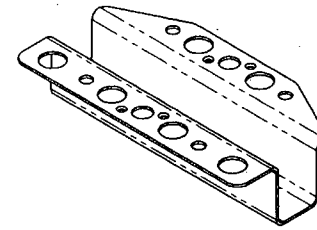
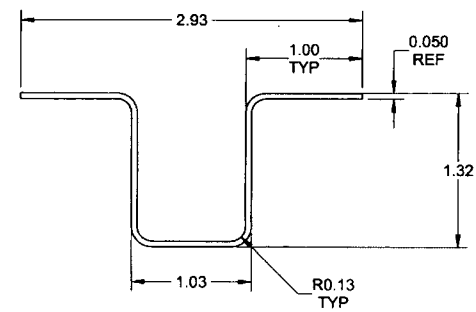
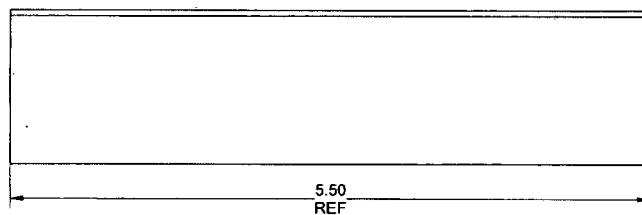
D4712-1F FLAT PATTERN BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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2013-12-23
ADS

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. C
MFG. APPR.	DL	D4712	SHEET 3 OF 5
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	SUPPORT BRACKET ASSY	NTS
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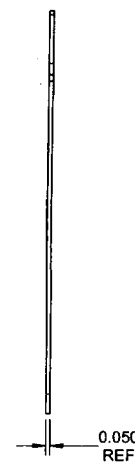
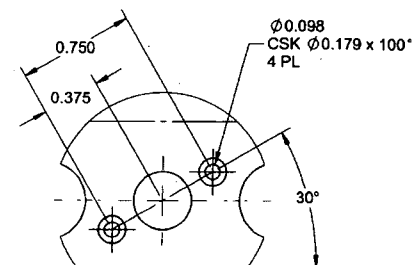
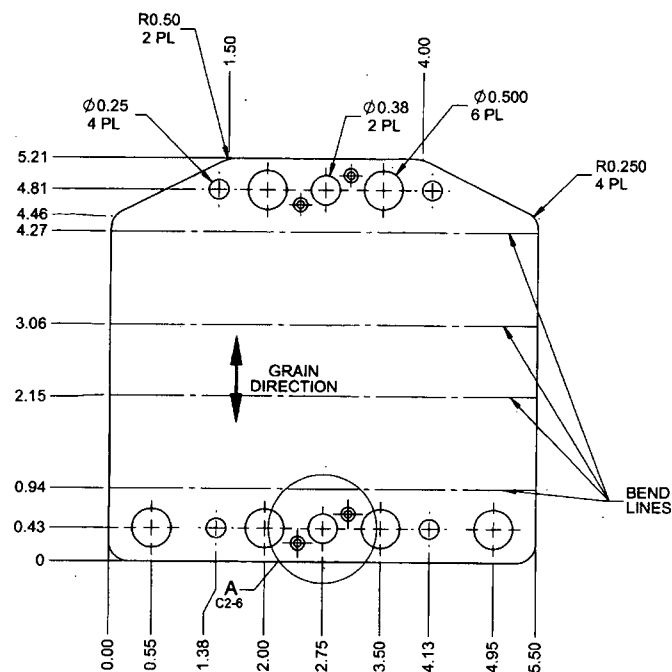


D4712-3 BRACKET

RELEASED
2013-12-23
ASS

- NOTES:**
- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	N	D4712	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT BRACKET ASSY	NTS
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D4712-3F FLAT PATTERN BRACKET

RELEASED
2013-12-23
125

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DS	D4712	SHEET 5 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	SUPPORT BRACKET ASSY	NTS
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